

Work Order ID 161768

Tuesday, May 23, 2017 9:40:24 AM

161768

Page 1

Item ID: D2150 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Packer Doubler, Hinge
 Start Date: 6/2/2017 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/9/2017 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: MAY 24 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2150	Rev A

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.27
 FLOW CNC Waterjet 1-Cut as per Dwg D2150 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary

(12) _____ 06/17/06/09

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.10
 Quality Control

(12) _____ 06/17/06/09

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.20
 Quality Control

12 _____

DAE
38
9-89
JUN 12 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab Memo Deburr	0.00 0.21							
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.24							
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.12							

WLA
DAS
38
9-89

(X12) *2.1706/12*
BEB

12 @ 17-06-20 *DS 34 9-89*

START TIME: *3:40* FINISH TIME: *4:10*
 OVEN TEMPERATURE:

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		☐ OTHER : _____							

Work Order ID 161768

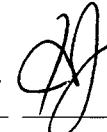
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160						12			
QC	Memo	0.10							
Quality Control									JUN 2 1 2017
170	Identify as per dwg & Stock Location: <u>St002</u>	0.00							
170						12			
Packaging	Memo	0.10							
Packaging									DAS 6 9-89
									JUN 2 1 2017
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	1.00							
Quality Control									17/6/27 

DAS
21
9-89

JUN 2 2 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, May 23, 2017 9:40:23 AM

Page 1

Work Order ID: 161768

161768

Parent Item: D2150

D2150

Parent Item Name: Packer Doubler, Hinge

Start Date: 6/2/2017

Required Date: 6/9/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP C00.11.27Re-format (mpp 2101)EC
IPP Rev:D 06-08-23 Now on Waterjet JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	91.6500	0.025	0.263158			

M2024T3S 040

2024-T3 .040 sheet

**

06/17/06/09

Location

Loc Qty

Loc Code

MAT022

91.65

m136770

1.25

m137041

11.9

m137237

78.5

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

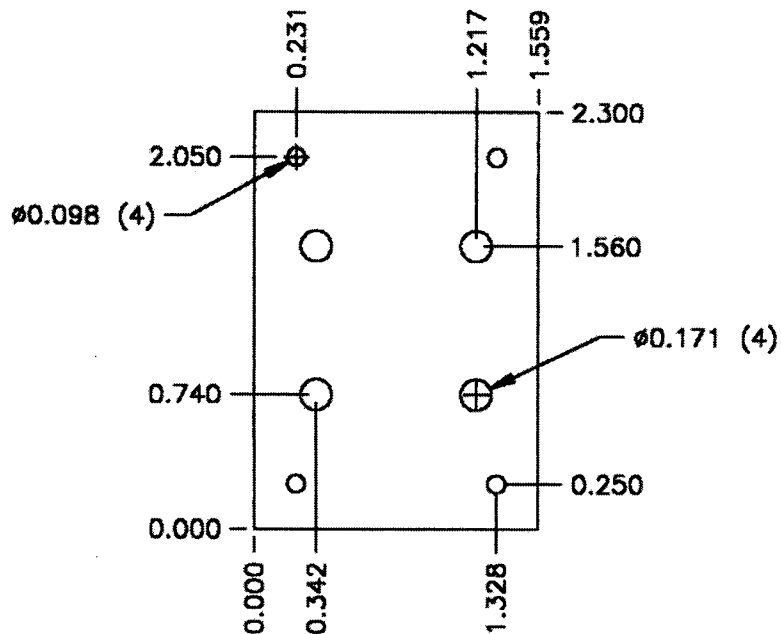
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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
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Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
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Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. A
CHECKED	APPROVED	D2150	SHEET 1 OF 1
DATE	TITLE	SCALE	
95:05:01	PACKER	1:1	

RELEASED
96/06/13 BSW



SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161768 KLS
17-05-24

MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS